

# Work Order ID 69714

Tuesday, May 17, 2011 3:29:46 PM



Page 1

Item ID:	D3282-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Float Web (206L/407)					
Start Date:	5/17/2011	Start Qty:	5.00	Cust Item ID:		
Required Date:	5/24/2011	Req'd Qty:	5.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>11-05-17</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3282	Rev C

100		Skidtubes	0.00						
Skidtubes		Memo	0.00						
Skidtubes		1-Cut to length as per Dwg D3282.							
		2- inspect for surface damage as per QSI0018							
		3- Deburr							

DP 11-5-17 (5)

110		HAAS CNC VERTICAL MACHINING #1	0.00						
HAAS 1		Memo	0.00						
HAAS CNC vertical machine #1		1-Machine as per Folio FA579 & Dwg D3282							
		2-Deburr							

B-A 11/08/04

Pto →

120		QC2- Inspect parts off machine FAI/FAIB	0.00						
QC		Memo	0.00						
Quality Control									

B-A 11/08/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3222-041 PAR #: N/A Fault Category: Machining NCR: Yes ☒ No ☐ DQA: JA Date: 11.08.17  
 Resolution: use rework ~~Good As Is~~ Disposition: use rework ~~Good As Is~~ QA: N/C Closed: JA Date: 11.8.19

NCR: <u>69714</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.08.15	1/0	on qty 15 webs only. SEVERAL HOLES ARE OVERTIZED, FOR INSTALLATION OF DOUBLERS, UP TO Ø0.153 R.C. Drill closed up with chips causing the hole to be larger. Process (Program) tooling, <del>Fitro</del> to all good).	<u>CP</u> 11.08.15 <u>Q51042</u>	USE MS20470ADS RIVETS AS REQ'D. OPEN AFFECTED HOLES IN DOUBLER. <u>B114988 x 5</u>	SAD 11-08-16	<u>S</u> wbs/16	<u>CP</u> 11.08.15 <u>Q51042</u>	<u>S</u> wbs/16

NOTE: Date & initial all entries

[illegible]

Page 2

**Accept**

[illegible]**Setup Start**

**Stop**

**Cust Item ID:**

[REDACTED]

**Customer:**

**Reference:**

Run Start

**Stop**

### Operation Description

### Set Up/ Run Hours

**Tool ID****Tool #**Plan  
Code

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

130

QC8- Inspect parts - second check

0,00

\_\_\_\_\_

QC

## Memo

0.00

## Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

\_\_\_\_\_

HandFinish

## Memo

0.00

## Hand Finishing

150

QC3- Inspect Part Finish

0.00

■■■■■

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69714**

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Page 3

Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

Start Date: 5/17/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web  
A/RN/ALPS-3 116551

SAJ 11-08-15

(5)

170

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

S w/08/16

(5)

180

0.00



Packaging

Identify as per dwg &amp; Stock Location:

Memo

0.00

46

DP

11-8-16

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\*NOTE: Date & initial all entries

**Work Order ID 69714**

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Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

Start Date: 5/17/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18

11-08-16  
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, May 17, 2011 3:29:40 PM

Page 1

Work Order ID: 69714

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)

Start Date: 5/17/2011

Required Date: 5/24/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:B 05.09.23 Procedure change KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2792-130 EXTRUSION		Manufactured	No			160	Each	30.0000	1	5			
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Location	Loc Qty	Loc Code
HALL	30	
61630	30	

⑤ 11-5-17  
SAD 11-08-15

D3283-1 Doubler		Manufactured	No			160	Each	55.0000	2	10			
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Location	Loc Qty	Loc Code
ST045	29	
66947	29	
ST048	26	
66553	26	

10

MS20470AD4-7 Rivet, Universal Head		Purchased	No			100	Each	1,872.000	57	285			
---------------------------------------	--	-----------	----	--	--	-----	------	-----------	----	-----	--	--	--

Location	Loc Qty	Loc Code
ST320	1872	
116081	572	
117423	1300	

279

SAD 11-08-15

★ USE MS20470ADS  
RIVETS AS REQ'D  
FOR OVERSIZED HOLES  
CP 11.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	60714
<b>Description:</b> Float Web		<b>Part Number:</b>	D3282-041
<b>Inspection Dwg:</b> D3282	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST



☒ First Article
 ☐ Prototype

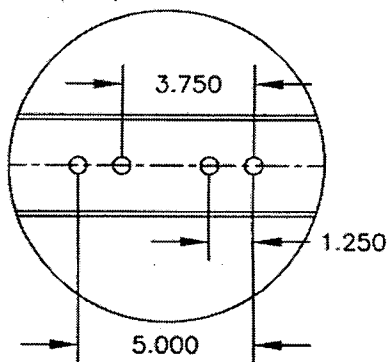
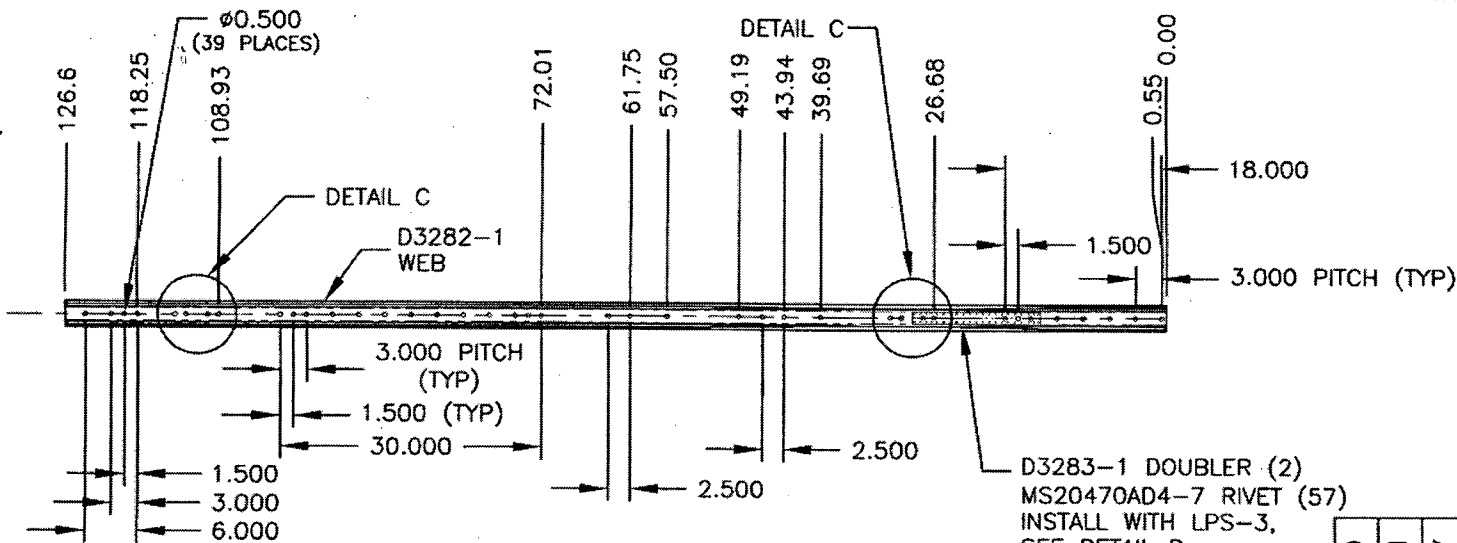
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.610	✓		Tape	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
3.000	+/-0.010	3.000	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
30.000	+/-0.010	30.000	✓		Tape	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
72.01	+/-0.030	72.01	✓		Tape	GA-12
61.75	+/-0.030	61.75	✓		"	"
57.50	+/-0.030	57.50	✓		"	"
49.19	+/-0.030	49.19	✓		"	"
43.94	+/-0.030	43.94	✓		"	"
39.69	+/-0.030	39.69	✓		"	"
26.68	+/-0.030	26.68	✓		"	"
0.55	+/-0.030	0.551	✓		Vern	GA-01
1.970	+/-0.010	1.972	✓		"	"
2.38	+/-0.030	2.383	✓		"	"
0.05	+/-0.030	0.052	✓		"	"

<b>Measured by:</b>	D.A.	<b>Audited by:</b>	[Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	11/08/04	<b>Date:</b>	11/08/05	<b>Date:</b>	N/A

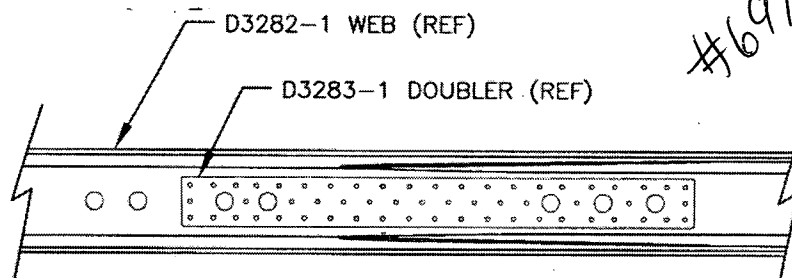
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	[Signature]



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
CHECKED		APPROVED		DRAWING NO.	REV. C
DATE	05.08.09			D3282	SHEET 1 OF 2
				TITLE	SCALE
				05.08.09	1:20
A		04.05.05		NEW ISSUE	
B		05.03.16		MOVE HOLES, ADD D3390-1 DOUBLERS	
C		05.08.09		REMOVE D3390-1, NOW MACHINED	



**DETAIL C**  
SCALE 1:5  
RIVET HOLES NOT SHOWN  
FOR CLARITY



**DETAIL D**  
SCALE 1:5

RELEASD

05.09.12 7/8

**D3282-041 FLOAT WEB**

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

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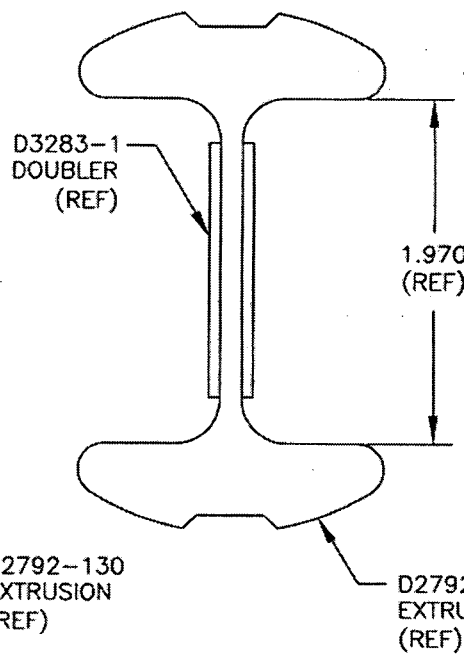


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DATE	05.08.09	TITLE	D3282	REV. C
				SHEET 2 OF 2
				SCALE
				1:20
				05.04.12

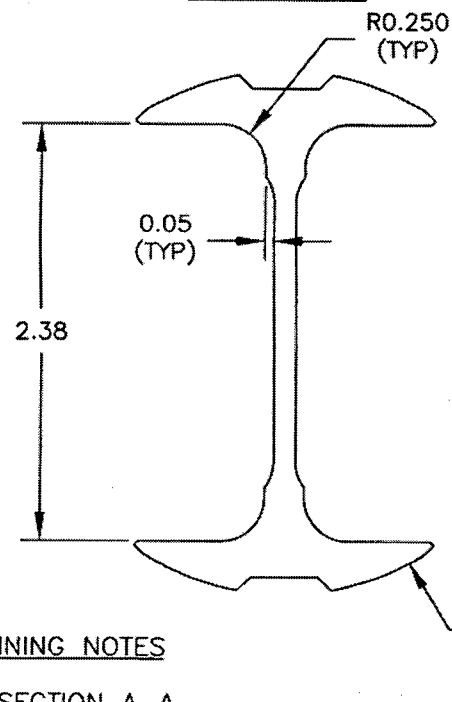
#69714

RELEASED  
05.04.12

### SECTION B-B

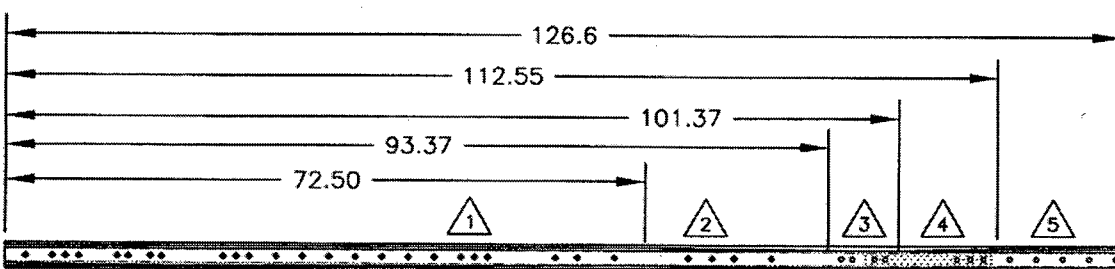


### SECTION A-A



### D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 ( $\phi 0.128$  REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



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